

Date: Monday, 13/04/2009 8:22:21 AM
 User: Julie Dawson

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	MOUNTING LUG
Job Number :	47110		
Estimate Number :	10256		
P.O. Number :		Part Number :	D22303
This Issue :	13/04/2009	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D2230 REV F
First Issue :	1/1	Project Number :	N/A
Previous Run :	46516	Drawing Revision :	F
Written By :		Material :	
Checked & Approved By :	<u>J.D. 09.04.13</u>	Due Date :	24/04/2009
Comment :	Est D 00.05.18 Added inspection level 8, and removed P/O for powder coat EC		
		Qty:	160
		Um:	Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2423	Lug Extrusion
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Comment: Qty.: 0.0717 f(s)/Unit Total: 11.4744 f(s)

Lug Extrusion

D2423

Batch: 1144529mk 09/04/16(162)

2.0	D22303P	LUG
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 160.0000 Each(s)

LUG

mk 09/04/16(162)

3.0	BAND SAW	BAND SAW
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**Comment:** Band Saw

Cut D2423 extrusion to 0.82"

Batch: N/A mk 09.04.16mk 09/04/16(162)

4.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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**Comment:** HAAS CNC VERTICAL MACHINING #1

Machine per folio D2230-3

Check for crack while loading into the machine.

H.A. 09/04/21 / 88 09/04/19(162)

5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINEH.A. 09/04/21 / 88 09/04/19(162)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2230-3 PAR #: N/A Fault Category: Prod / Machined parts NCR: (Yes) No DQA: D Date: 08/05/05
 Resolution: SCRAP Disposition: Scrap QA: N/C Closed: ID Date: 09/05/06

NCR: <u>47110</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/04/20	4.0	Scrap 3 pieces, undersized. Should be .750 ±.010 actually .731 → .736. Piece lifted in vice not clamped tight enough. R.C. operator Error	CP 09.04.23 per QSI 042	Scrap - Replace: B <u>44529</u> Qty <u>3</u>	09/04/20 S	S 09/04/20	CP 09.04.23 per QSI 042	S 09/04/20

NOTE: Date & initial all entries

Date: Monday, 13/04/2009 8:22:21 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MOUNTING LUG

Job Number: 47110

Part Number: D22303

Job Number:



Seq. #: Machine Or Operation: Description :

6.0 QC8 SECOND CHECK



Comment: SECOND CHECK

09/04/27 (162)

7.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
1- deburr rough edges if necessary

09/04/27 (162)

8.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
Acid etch and Alodine as per QSI 005 4.1

MD/BK

09/04/27

X162

9.0 POWDER COATING POWDER COATING



Comment: POWDER COATING
Powder Coat Gloss White (ref. 4.3.5.1) per Dart QSI 005 4.3

START TIME: 14:30
OVEN TEMPERATURE: 320°
FINISH TIME: 14:40

MD/BK

09/04/29

X162

10.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/INSPECT POWDER COAT

FL 09/04/30 (162)

11.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: ST 476

SS 09/05/04 (162)

12.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/05/05

Job Completion



MF
09-05-04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

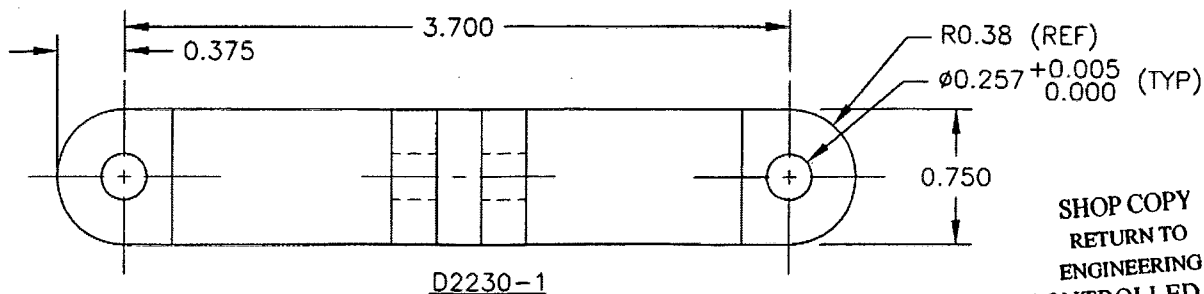
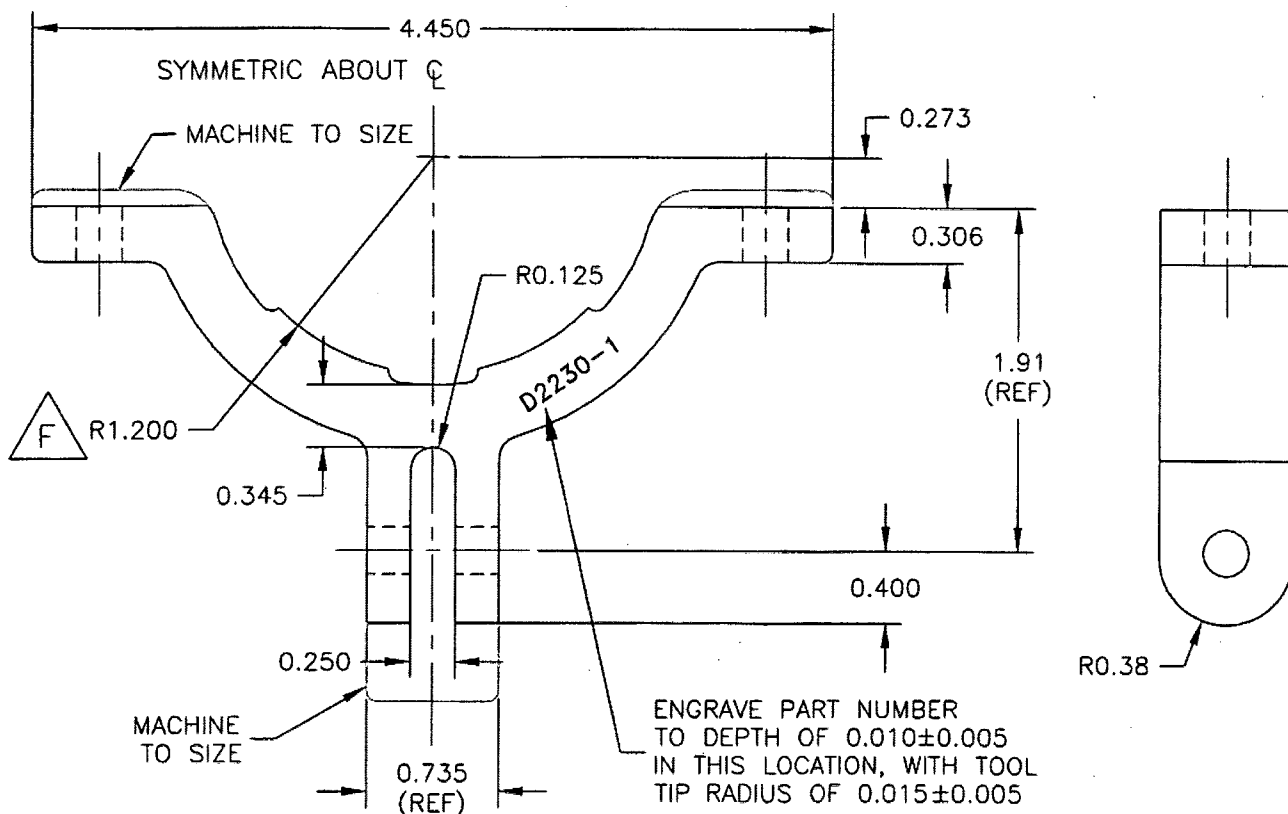
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	<i>CP</i>	DRAWN BY	<i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO. D2230 REV. F SHEET 1 OF 2
DATE	99.12.13	TITLE	MOUNTING LUG	SCALE 1:1
C	94.03.30	RE-DESIGN		
D	95.01.04	RE-DESIGN		
E	95.01.04	RE-DESIGN		
F	99.12.13	REDESIGN; R1.200 WAS R1.100		

RELEASED
99.12.21 DS



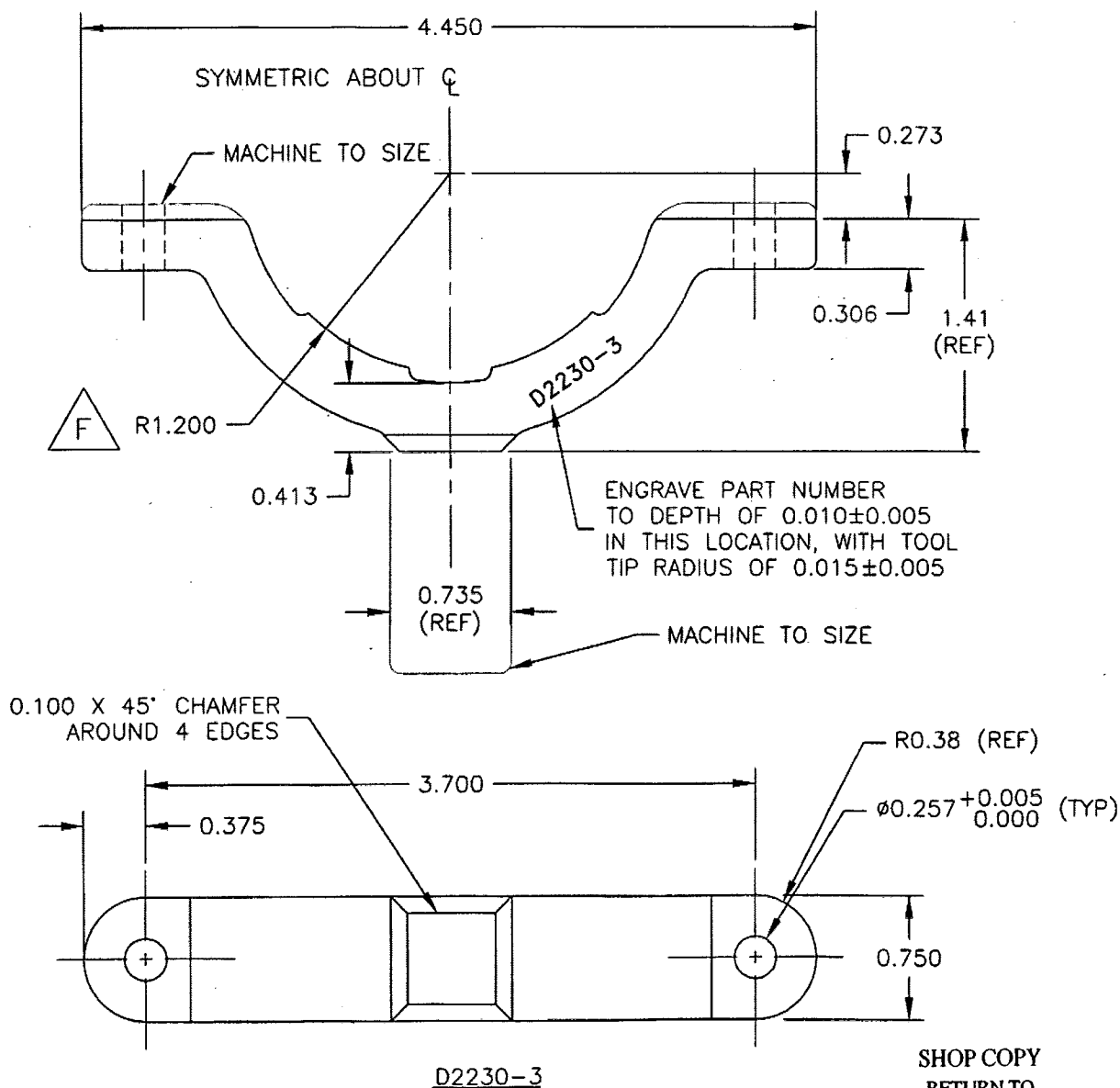
MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000-0.015
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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WITHOUT NOTICE
WORK ORDER



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2230	REV. F SHEET 2 OF 2
DATE 99.12.13		TITLE MOUNTING LUG	SCALE 1:1

RELEASED
79 12 21 DS



MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000-0.015
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED NO. 47110

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